December-17-12 3:11:04 PM

| Revision ID: | 03065-3 tep Spacer | | | | Accept | *N9 | ററ | 040 | 100 |)* s | etup Start Stop | I XI | S1* |
|---|-----------------------|---|-------------|--------------|-----------------------------|---|----|--------|--------------|------------------------------|--------------------|------------------|----------------|
| | 7/12/2012 St | art Qty: 39.00 eq'd Qty:/30.00 | 80 | *30* *30* | | Cust l Custo | | | | | эц | *N | S2* |
| | | MLJ | | | | · · · · · · · · · · · · · · · · · · · | | ate: | | R | un Start Stop | 17 | R1* |
| Sequence ID/ Work Center ID | | eration scription | | | Set Up/ Run Hours | Tool | ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revision | Nbr | | | · · · · · · · · · · | - · · · · · · · · · · · · · · · · · · | | | | - · ~ · · · - · - · · | | | Stamp |
| D3065 | Rev B | : | | | | | | | | | | | |
| *100 *100* Waterjet FLOW CNC Waterjet 2024.04 | | DW WATER JET Memo 1-Cut as per if necessary | r Dwg D E | Dwg Rev: 3 | 0.00 0.00 Prog Rev: 3 | 2-Deburr | | ·-·· | | 69 | _0 | | Jm13-3-1 |
| *110 *110* QC Quality Control | QC2 | 2- Inspect parts off m Memo | achine FAI/ | FAIB | 0.00 | | | | | 69 | 0_ | | Jm13-3- |
| 120 *120* QC | . QC8 | 3- Inspect parts - seco | ond check | | 0.00 | | | | | (ba) | 13-13- | 13 | DAS Og |

| | | | | | | | | | | | DQ | A: Da | ate: | |
|---------------|------|------------|------------|------------|--------|---|-----|------------|--|---|------------|---|------|---------------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-O | 100 | NFORN | AANCE / UPD | ATE | | | | |
| | | | | | | | | | | | QA Close | d: D | ate: | |
| Work Ord | or. | | | | | DISPOSITION | | | | AGAINST DE | PARTME | NT/PROCESS | | |
| Part I | No. | | | | | Rework Scrap Use-as-is Work Order Update | | N Therm | Skid-tube Machining oforming Large Fab | Crosstube Small Fab Finishing Composite |] P | Water Je rod. Eng. Coor tore/Packaging Supplie | | Engineering Quality Other |
| Root | | | Γ | 1 | Descri | ption of work order update | | Initial | Actio | | Sign & | | | |
| Cause | | Date | Step | Qty | | or Non-conformance | ı | nief Eng | Descrip | | Date | Verification | on | QC Inspector |
| Doc/Data | | | <u> </u> | | | | 1 | Ĭ | | | | | | |
| Equip/Tooling | П | | | | | | | | | | | | | |
| Operator | | | 1 | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Unapproved | | · L | | | | | | | | | | | | |
| | | | | | ···· | | AUL | T CATE | GORY | | | | | |
| Landi | ng (| Gear | | | , | General | _ | _ | | | _ | | _ | - |
| | | Bending | | | | Bend | | Grain | | | Ovalized | | | Pressure/Forced |
| İ | | Centre No | ot Concer | ntric to (| o/s | BOM/Route | | Hardwa | re | | Over/Und | ler tolerance | | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | L | Inspecti | on Incomplete | | Part Inco | rect | | Weld |
| | | Crushed/ | Crimped. | | | Burrs | | Instructi | ions Incomplete/Ur | nclear | Part Lost, | Missing | L | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | _ | Mainte | nance | | Part Mov | ed | | |
| | | Heat Trea | at | | | Countersink | | Mislabe | led | | Positione | d Wrong | _ | - |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | | | Power Lo | ss/Surge | | Other |
|] | | Ripples in | Bend | | | Drill Holes | | Offset | | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:11:04 PM

94418

| Item ID: Revision ID: Item Name: Start Date: Required Date: | D3065-3 Step Spacer 17/12/2012 02/01/2013 | Start Qty: 30.00 Req'd Qty: 30.00 | *30* | Accept | *N900 | ID: | 10 | 0* s | etup Sta Sto | 1.71 | S1* S2* | |
|--|---|---|----------------------|----------------------------|-----------|-------|--------------|---------------|-----------------|------------------|----------------------|----|
| Reference: | ·· | req a Qiy. 50.00 | *30* | | Customer: | | | | | | | |
| Approvals: | Process Pla QC: | n: | Date: | Tooling: SPC (Y/N): | | ate: | - | R | tun Sta | " \ | R1* R2* | |
| Sequence ID/ Work Center IE 130 *120* Small Fab Small Fab |) | Operation Description Small Fab Memo Deburr Stack | | Set Up/ Run Hou 0.00 | Tool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | |
| *140 *140 *Brake NC Brake NC | | NC BRAKE Memo Bend as per E | Owg D3065 | 0.00 | s | | | 69 | | | \$ 13/03 \$ 13/03 | 3/ |
| *150 *150* QC Quality Control | | QC5- Inspect part complet Memo | eness to step on W/O | 0.00 2 | 321 | | | 69 Com | | - | | |

| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORN | MANCE / UPI | DATE | QA Closed: | Date: | |
|---|-----|---|--|---------------------------------------|----------|---|-----|--|---|---|--|---|--|
| Work Orde | er: | | | , | | DISPOSITION | | | | AGAINST DE | | | · . |
| Part I | - | | | · · · · · · · · · · · · · · · · · · · | <u>-</u> | Rework Scrap Use-as-is Work Order Update | | Therm | Skid-tube Machining Moforming Large Fab | Crosstube Small Fab Finishing Composite | 4 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root Cause | | Date | Step | Qty | | ption of work order update or Non-conformance | 1 | Initial nief Eng | | ion ription | Sign & Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | | |
| | | | | | | | AUI | LT CATE | GORY | | | | |
| Landi | | Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in | Crimped, et n Strip in i Bend | Tube | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes | | Instruct Mainte Mislabe Misread Offset | on Incomplete ions Incomplete/l enance eled | Jnclear | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N | ct sissing Vrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| | ı i | Torque W | laves in F | extrusion | ı I | Drawing | 1 | IOut of 0 | Calibration | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

94418

| December-17-12 | ? 3:11:04 PN | 1 | | | 942 | 118" | | | | | | | Page (| 3 |
|--|--|---|--------------|--------------|------------------------------|-----------------------------|-------|--------------|--------------|--------------|---------------|------------------|----------------|--------------------|
| Item ID: Revision ID: Item Name: Start Date: Required Date: Reference: | D3065-3 Step Spacer 17/12/2012 02/01/2013 | Start Qty: 30.00 Req'd Qty: 30.00 | | *30* *30* | Accept | *N900 Cust Item Customer: | ID: | 1100 |) * | Setup | Start Stop | IVI | S1* S2* | |
| Approvals: | Process Pla | un: | | | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | *N *N | R1* | |
| Sequence ID/ Work Center II 160 *160* HandFinish Hand Finishing |) | Operation Description Chemical Conversion Coa | at per QS100 | 05 4.1 | Set Up/ Run Hours 0.00 | Tool ID | Tool# | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp | |
| 170 *170* QC Quality Control | | QC3- Inspect Part Finish Memo | | | 0.00 | | | | 69 | <u> </u> | · | | J | ~ 3 03 2 |
| *180 *180* Packaging Packaging | | Identify as per dwg & Stoo | ck Location | GA | 0.00 | | | | 69) | <u> </u> | | | J137 | /03/22 |

| | | • | | | | | | | | | | DQA: | Dat | te: | |
|---------------|------|------------|------------|------------|--------|----------------------------|---------|----------|-----------------|-----------|-----|---------------|---------------|-----|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | O | NFORM | /ANCE / UP | DATE | | - | | • | |
| | | | | | | | | | | | (| QA Closed: | Dat | te: | |
| Work Orde | er. | | | | | DISPOSITION | | | | AGAINST D | EΡ | ARTMENT | PROCESS | | |
| VVOIR OIG | ٠,٠ | | | | | Rework |] | | Skid-tube | Crosstube | 7 | | Water Jet | | Engineering |
| Part 1 | No. | | | | | Scrap | | | Machining | Small Fab |] | | d. Eng. Coor. | | Quality |
| | | | | | | Use-as-is | | • | noforming | Finishing | 4 | Rec/Stor | e/Packaging | | Other |
| NCR I | No. | | | | | Work Order Update | | | Large Fab | Composite | | | Supplier | Ш | |
| Root | | | | | Descri | ption of work order update | | Initial | · Ac | tion | | Sign & | | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Cr | nief Eng | Desc | ription | 1 | Date | Verification | n | QC Inspector |
| Doc/Data | Ц | | | | | | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | • | | ١ | | | | |
| Operator | Ш | | | | | | | | | | ١ | | | | |
| Material | Ш | | | | | | | | | | 1 | | | | , |
| Setup | | | | | | | | | | | Ì | | • | | |
| Other | Ш | | | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | _ | | | | | | | | |
| | | | | | | F | AUI | LT CATE | GORY | | | | | | |
| Landi | ng G | Gear | | | | General | | - | | | _ | | | _ | • |
| | Ш | Bending | | | | Bend | <u></u> | Grain | | <u>L</u> | _ ' | Ovalized | | ┕ | Pressure/Forced |
| | | Centre N | ot Conce | ntric to (| o/s | BOM/Route | | Hardwa | re | | _ | Over/Under | tolerance | L | Temperature/Cure |
| | Ш | Cracks | | | L | Broken/Damaged | L | Inspecti | on Incomplete | L | ال | Part Incorred | ct | | Weld |
| | | Crushed/ | Crimped. | | | Burrs | L | Instruct | ions Incomplete | 'Unclear | | Part Lost/Mi | issing | | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | nance | | | Part Moved | | | |
| | | Heat Trea | at | | | Countersink | | Mislabe | led | | | Positioned V | Vrong | | _ |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | 1 | | | Power Loss/ | Surge | | Other |
| | | Ripples in | Bend | | | Drill Holes | | Offset | | | | | | | |

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-17-12 3:11:04 PM

Item ID: D3065-3 Accept *N900040100* Setup Start Revision ID: Item Name: Step Spacer Start Date: 17/12/2012 **Start Otv: 30.00** *30* **Cust Item 1D: Required Date:** 02/01/2013 Req'd Qty: 30.00 Customer: Reference: Run Start Approvals: Process Plan: ____ Date:__ Tooling: Date: Stop ____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Code Qty Otv Number Stamp 190 QC21- Final Inspection - Work Order Release 0.00 *100* MLJ 13-03-22 OC Memo 0.00 Quality Control

MG 13-3-28

| | | | | | | | | | DQA: | Date: | |
|---|--------------------|-------------|----------|--------|--|-----------|--|---|--------------|---|--|
| NCR: | res / No | | | | WORK ORDER NON-C | ONFOR | MANCE / UP | DATE | · | | |
| | | | | | | | | | QA Closed: | Date: | |
| Work Orde | er: | | • | | DISPOSITION | | | AGAINST DE | PARTMENT | /PROCESS | |
| Part I | No | | | | Rework Scrap Use-as-is Work Order Update | Thern | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | 4 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | | | Descri | ption of work order update | Initial | Act | tion | Sign & | | |
| Cause | Date | Step | Qty | C | or Non-conformance | Chief Eng | Desci | ription | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | |
| | | | | | | AULT CATE | GORY | | | | <u>. </u> |
| Landi | ng Gear Bending | | | | General Bend | Grain | | | Ovalized | Γ | Pressure/Forced |
| | Centre N | lot Conce | ntric to | o/s | BOM/Route | Hardwa | ire | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | Inspect | ion Incomplete | | Part Incorre | ct | Weld |
| | | /Crimped | | | Burrs | Instruct | ions Incomplete/ | Unclear | Part Lost/Mi | issing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | Mainte | enance | | Part Moved | | |
| | Heat Tre | at | | | Countersink | Mislabe | eled | | Positioned V | Vrong | _ |
| ! | Inspection | on Strip in | Tube | | Cut Too Short | Misread | t | | Power Loss/ | 'Surge | Other |
| | Ripples i | n Bend | | | Drill Holes | Offset | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-17-12 3:11:09 PM

Work Order ID: 94418

94418

Parent Item: Parent Item Name: Step Spacer

D3065-3

D3065-3

Start Date: 17/12/2012

Required Date: 02/01/2013

Start Qty: 30.00

Required Oty: 30.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Qty per Kit Total Qty Date Item Name Status Item ID Purch Item Location Location Seq ID Measure Hand Otv Issued Issued M2024T3S 040 Purchased No 100 sf 262.7023 0.2178 *M2024T3S 040* ** 2024-T3 .040 sheet

> **Location** Loc Qty Loc Code MAT022 262.7023252 120605 65.8254832 121197 64.996842 122136 34.78 123217 97.1 183217

| | | DQA: | Date: | |
|---------------|-------------------------------------|-------------|-------|--|
| NCR: Yes / No | WORK ORDER NON-CONFORMANCE / UPDATE | | | |

| | | | | | | | | | | | QA Closed: | Date | 2: |
|---------------|--|------------|------------|----------|----------|--|-----------|------------|---|---|--------------|---|---------------------------|
| Work Orde | er: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Part I | No. | | | | | Rework Scrap Use-as-is Work Order Update | | i Thern | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | | | | Descri | ption of work order update | Ini | tial | Ac | tion | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Chie | f Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | | | | | | • | 1 | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | İ | | | | | | | | | | |
| | | | | | | | AULT | CATE | GORY | | | | |
| Landi | ng (| 7 | | | | General | | | | _ | 1 | _ | |
| | <u></u> | Bending | | | <u> </u> | Bend | \vdash | irain | | <u> </u> | Ovalized | <u> </u> | Pressure/Forced |
| 1 | | Centre No | ot Concei | ntric to | o/s | BOM/Route | - | ardwa | | | Over/Under | <u>-</u> | Temperature/Cure |
| | L | Cracks | | | <u>_</u> | Broken/Damaged | \vdash | | ion Incomplete | <u> </u> | Part Incorre | - t | Weld |
| | | Crushed/ | Crimped. | | | Burrs | | | ions Incomplete/ | Unclear | Part Lost/M | | Wrong Stock Pulled |
| | L | Cuffs | | | | Contamination | - | | enance | | Part Moved | | |
| • | | Heat Trea | at | | | Countersink | | 1islabe | | | Positioned \ | | _ |
| | $ldsymbol{ld}}}}}}$ | Inspectio | | Tube | <u> </u> | Cut Too Short | - | 1isrea | t | | Power Loss/ | 'Surge | Other |
| | $ldsymbol{ld}}}}}}$ | Ripples in | n Bend | | | Drill Holes | Ш٥ | ffset | | | | | |
| | | Torque W | Vaves in E | Extrusio | ı L | Drawing | \vdash | | Calibration | | | | |
| | | Turning S | equence | | _ | Finish | Ш٥ | ut of | Sequence | | | | |
| 1 | 1 | WEYEN TW | ist in Tuk | 20 | 1 | Folio | | nitside | Dimensions | | | | |

| DART AEROSPACE LTD | Work Order: | 94418 |
|------------------------------|--------------|-------------|
| Description: Step Spacer | Part Number: | D3065-3 |
| Inspection Dwg: D3065 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------------|--------|-------------------------|---------------------------------------|
| 1.260 | +/-0.010 | 1.267" | _ | | | |
| 3.260 | +/-0.010 | 3268" | _ | | | |
| 5.260 | +/-0.010 | 5.267" | _ | | | |
| 6.520 | +/-0.010 | 6.524° | - | | | |
| 2.093 | +/-0.010 | 2.093" | _ | | | |
| 3.936 | +/-0.010 | 3.935" | _ | | | |
| 4.186 | +/-0.010 | 4.196" | _ | | | |
| Ø0.129 | +0.005/-0.000 | 0.129" | - | | ν | |
| Ø1.250 | +0.005/-0.000 | 1.250" | - | | V | |
| Pitch 1.204 | +/-0.005 | 1.207" | _ | | V | |
| 0.040 | +/-0.010 | 0.039 | - | | V | |
| | | | | | | |
| | | | | | | |
| | | • | | | | |
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| | | | | | | A A A A A A A A A A A A A A A A A A A |
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| | | | | | | · · · · · · · · · · · · · · · · · · · |
| | | | | | | |
| | | | (0 A) | | | |

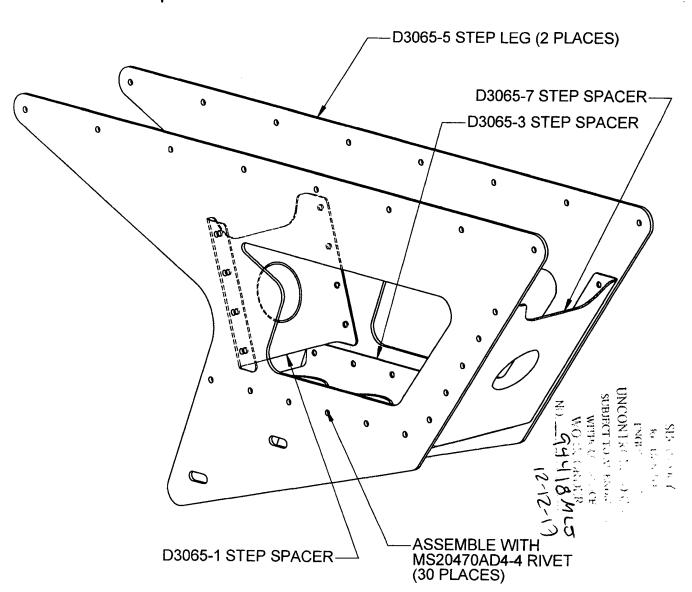
| Measured by: | Jm | Audited by: | 09 | Preliminary Approval: | |
|--------------|---------|-------------|----------|-----------------------|--|
| Date: | 13-3-13 | Date: | 13-03-13 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|------------|----------|
| A | 04.02.25 | New Issue P/O D3065-041 | KJ/RF | |
| В | 04.08.12 | Removed dimension 1.204 | KJ/JLM | |
| С | 06.06.23 | Dwg Rev. changed | KJ/JLM | |
| D | 07.09.06 | 0.040 dimension added | KJ/JLM . A | N1 |
| E | 12.10.10 | Ø0.129 was Ø0.128 | KJ # | M. |



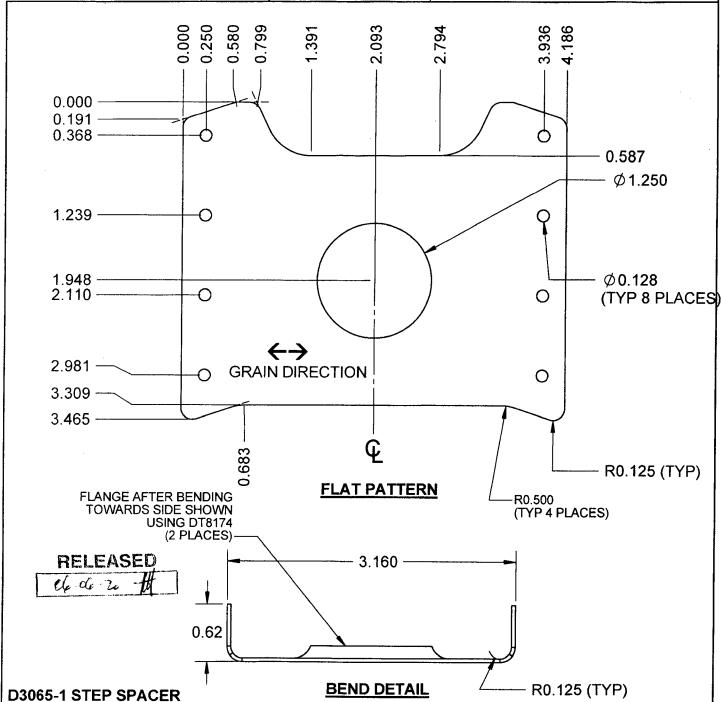
| DESIG | P | DRAWN BY | DART AEROSPACE HAWKESBURY, ONTARIO, CA | | |
|----------|------------|----------|--|--------------|--|
| CHECK | | APPROVED | DRAWING NO. | REV. B | |
| | PH | | D3065 | SHEET 1 OF 5 | |
| DATE | 00.0 |)E 00 | TITLE | SCALE | |
| <u> </u> | 06.0 | 05.23 | STEP LEG ASSEMBLY | 1:2 | |
| Α | 0: | 2.09.11 | NEW ISSUE | | |
| В | B 06.05.23 | | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5 | | |

RELEASED



D3065-041 STEP LEG ASSEMBLY





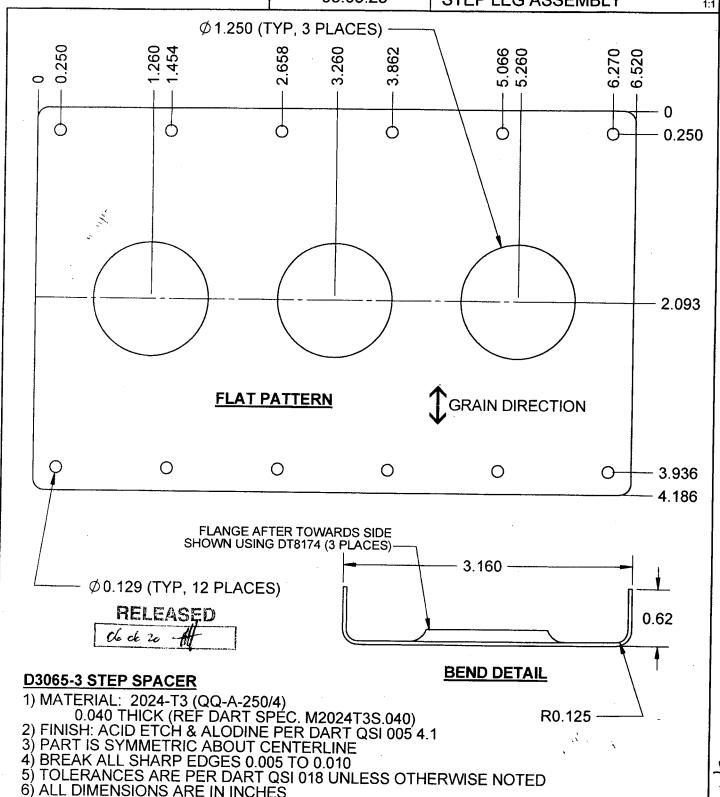
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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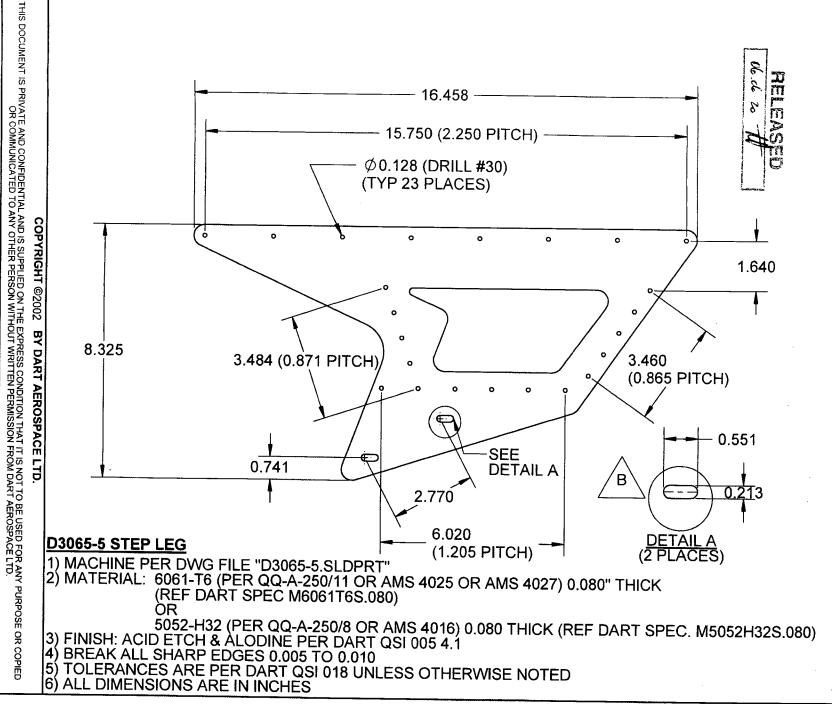
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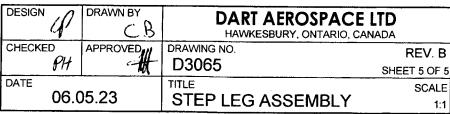
94418

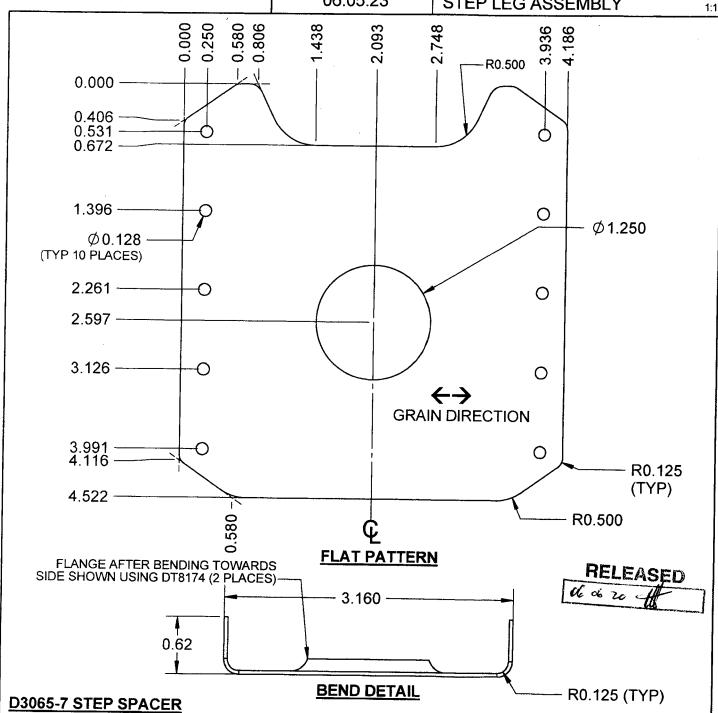
DART

DATE CHECKED 06.05.23 # DRAWING NO. D3065 STEP LEG DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA **ASSEMBLY** SHEET 4 OF 5 SCALE









- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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